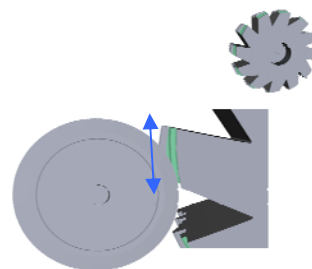


Braised Carbide Profilecutter Ø48 Z10

A16-210

The profile finishing operation is done in vertical oscillations following stepwise the profile. Stepsize is 0.04 mm. The method allows to generate a perfectly straight clearance. The profilecutter can then only be resharpener on the cutting face, as soon as the edge wears. The braised carbide being irregularly tipped, a pregrinding operations of the facegrinding is necessary, before polishing the face with a D31 wheel.



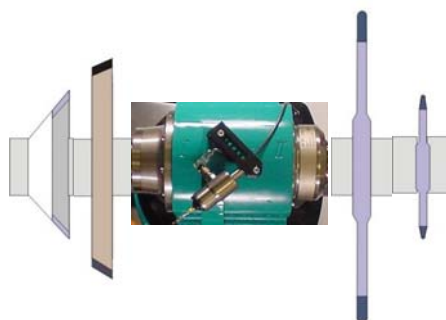
1. Cycletime for Production

Workpiece: Diameter 48 mm, Z 10, Length of cutting edge 10 mm Material CARBIDE					
Operations					
Feed [mm/Min]	2000	120	200	70	5000
Power [kW]		3	2	2	1
Cutting feed [m/s]		20	20	22	24
Used wheels					
Grinding time [s]	17	528	500	391	5071
Total cycle time	108 Min 27				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø125 D64
2	12V9 Ø100 D31
3	14F1 Ø150 D76
4	14EE1 Ø40 D46



2 1

3 4

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG Coolant: Synthetic Oil, pressure 6 bar
Control: Fanuc 310i Software: Quinto 5
Accessories:

Responsible engineer: OP. 22.6.10

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